

# Work Order ID 52604

October 3, 2009 8:42:47 AM



ASAP

Page 1

Item ID: PB67-43001-207

Accept



Setup Start



Revision ID: C

Stop



Item Name: Square Tube

Start Date: 10/05/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 10/06/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-10-03 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

B67-43001

C

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1- cut to length as per dwg  
2- make a chamfer on both ends of tube  
3- deburr

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

120

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1- drill holes as per dwg  
2- make a chamfer on both side of the 4 holes  
3- deburr

SH 09/10/05

SH 09/10/05

(+C) /

SH 09/10/05

(4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item ID: PB67-43001-207

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Start Date: 10/05/2009 Start Qty: 4.00

Cust Item ID:

Required Date: 10/06/2009 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC5- Inspect part completeness to step on W/O

0.00

2/5 09/10/05

QC

Memo

0.00

Quality Control

(4x)

4

140

Weld per dwg A/R Aluminum rod Batch: M108436

0.00

Large Fab

SY 09/10/05

(4x)

Large Fab

Memo

0.00

Large Fab

1- Weld assembly as per dwg

150

Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1- grind weld flush  
2- deburr

SY 09/10/05 (4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 3

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Item Name: Square Tube

Setup Start

Stop

Start Date: 10/05/2009 Start Qty: 4.00

Required Date: 10/06/2009 Req'd Qty: 4.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

0.00

27 S 02/10/05

(48)

f

QC

Memo

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

0.00

27 S 02/10/05

(48)

f

QC

Memo

Quality Control

180

Identify as per dwg &amp; Stock Location: WA

0.00

0.00

SAD 09-10-05

(4)

Packaging

Memo

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Page 4

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Cust Item ID:

Required Date: 10/06/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/10/06  
MF  
09-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 52604

Parent Item: PB67-43001-207RevB1

Parent Item Name: Square Tube



Start Date: 10/05/2009

Required Date: 10/06/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6TS1.000W.120		Purchased	No			100	f	0.0000	7.8072			
												
6061T6 SQ TUBE 1.00 x 1.00 x .125w												
PB67-43001-223RevB1		Manufactured	No			140	Each	48.0000	4.0000			
												
Square Cap												

M110680 → 7.8072

SY 09/10/05

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

47504

48

48

140

Each

45.0000

16.0000

~~M110680 → 7.42 ft~~

~~SY 09/10/05~~

CPL 09/10/05

PB67-43001-225RevB1

Manufactured No



Bushing

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

ST

44988

45

45

166

SY 09/10/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

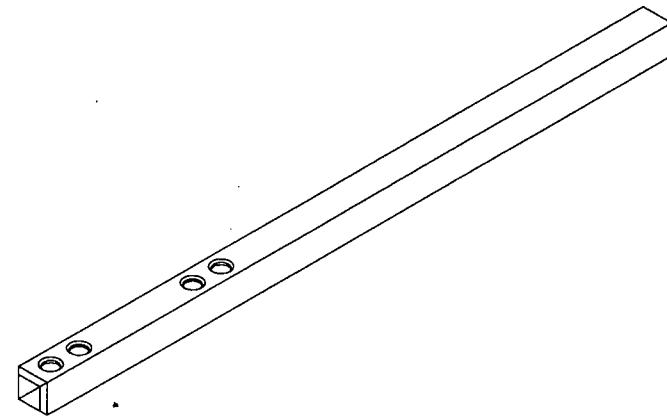
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

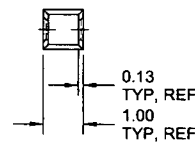
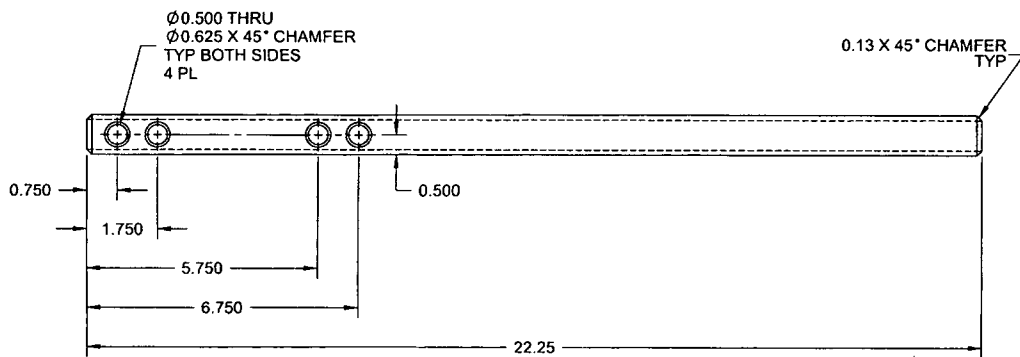
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**NOTE:** Date & initial all entries

#52604



**B67-43001-207 SQUARE TUBE**



**RELEASED**  
2009-09-26

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) SQUARE TUBING PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR PER AMS-QQ-A-200/8 (OR AMS 4160) REF. DART SPEC. M6061T6TS1.000W0.125
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.92 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGE 16 OF PREMIER AVIATION DRAWING NO. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.19
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AS			
CHECKED	EE	DRAWING NO. B67-43001-207		REV. C
MFG. APPR.	MP	TITLE SQUARE TUBE		SHEET 1 OF 1
DE APPR.	N/A	SCALE NTS		
DATE	09.02.19	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

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